

Spirit

Date: Monday, 22/09/2008 10:14:08 AM  
 \*User: Julie Lecocq

## Process Sheet

|                       |   |                  |                               |
|-----------------------|---|------------------|-------------------------------|
| Customer              | : CC-DAR01 Dart Aerospace Ltd.  | Drawing Name     | : FRONT OUTBOARD LEG ASSY, RH |
| Job Number            | : 42151 -2  | Part Number      | : D3782044                    |
| Estimate Number       | : 13322   | Drawing Number   | : D3782 REVA                  |
| P.O. Number           | :   | Project Number   | : N/A                         |
| This Issue            | : 22/09/2008 S.O. No. :   | Drawing Revision | : A                           |
| Prsht Rev.            | : NC  | Material         | :                             |
| First Issue           | : 22/09/2008 Type : SMALL /MED FAB  | Due Date         | : 05/10/2008                  |
| Previous Run          | : 42138   | Qty:             | 5 Um: Each                    |
| Written By            | :   |                  |                               |
| Checked & Approved By | : JLD 08.9.22   |                  |                               |
| Comment               | : Est Rev:A 08-05-19 new issue DD verified by:ec<br>Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC |                  |                               |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :         |
|---------|-----------------------|-----------------------|
| 1.0     | PACKAGING 1           | PACKAGING RESOURCE #1 |



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

|     |        |                        |
|-----|--------|------------------------|
| 2.0 | D37684 | Front Outboard Leg, RH |
|-----|--------|------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Front Outboard Leg, RH  
 batch: B40712 x1 B40974 x5

|     |        |      |
|-----|--------|------|
| 3.0 | D37871 | Foot |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Foot  
 batch: 40982

|     |          |          |
|-----|----------|----------|
| 4.0 | AN45 13A | EYE BOLT |
|-----|----------|----------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 eye Bolt  
 batch: M109712 (3) M109013 x9

|     |            |        |
|-----|------------|--------|
| 5.0 | AN960JD516 | Washer |
|-----|------------|--------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 Washer  
 batch: M109059  
 or (NAS1149D0568J)batch:

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



Date: Monday, 22/09/2008 10:14:08 AM  
User: Julie Lecocq

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: FRONT OUTBOARD LEG ASSY', RH

Job Number: 42151

Part Number: D3782044

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 MS21042L5 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

batch:

M108161

JS 08/10/10 (46)

7.0 D3762041 Front Leg Fitting Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Front Leg Fitting

batch:

40947x5 40948x1

JS 08/10/10 (46)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

FF 09/02/18

(3)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/18 (3)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

-1

10 9/2/18 (3)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18 (4)

Job Completion



MF

09-02-18

| W/O: |      | WORK ORDER CHANGES |  |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

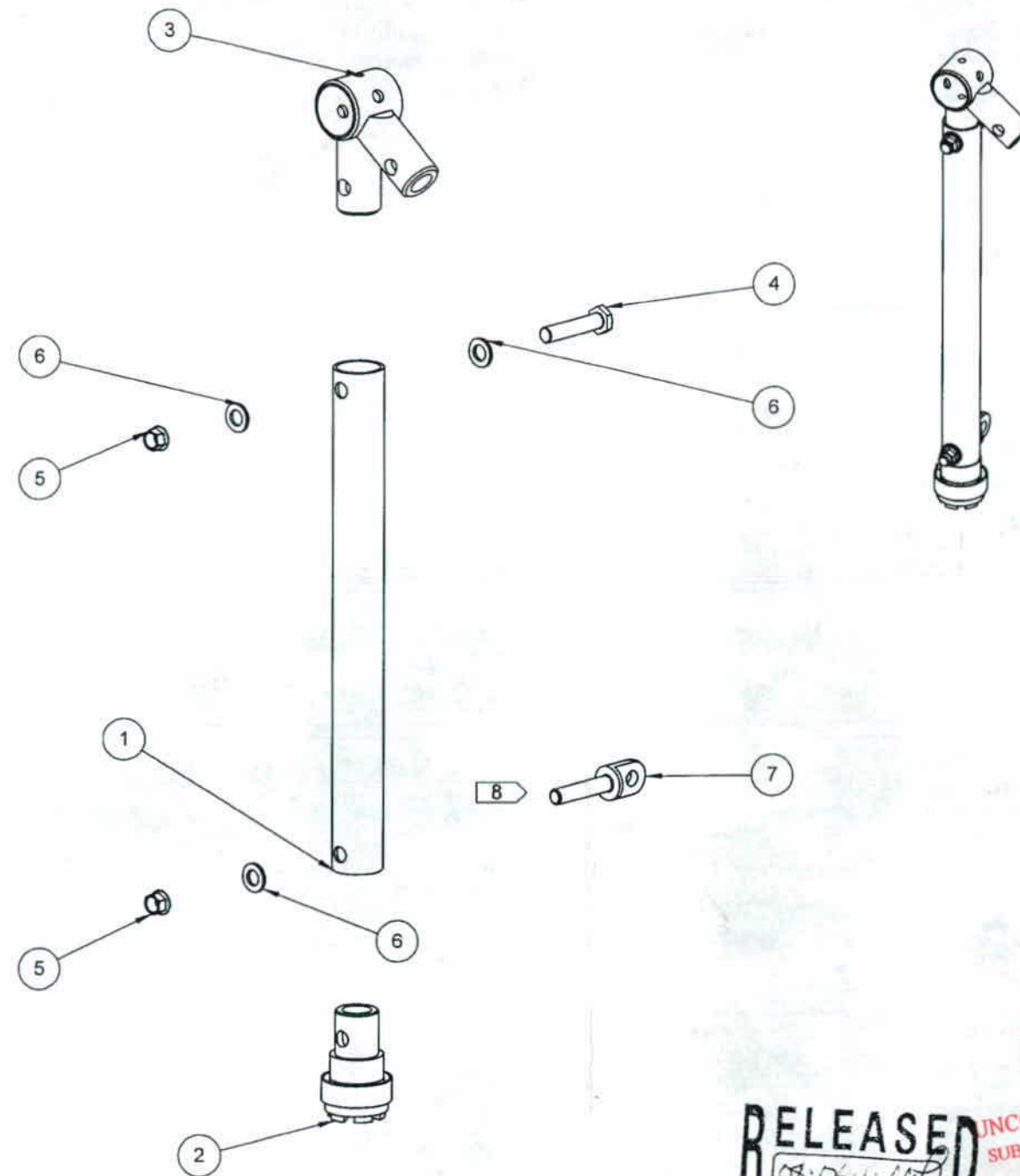
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| ITEM NO. | PART NUMBER   | DESCRIPTION            | QTY. (-041) |
|----------|---------------|------------------------|-------------|
| 1        | D3768-1       | FRONT INBOARD LEG      | 1           |
| 2        | D3787-1       | FOOT                   | 1           |
| 3        | D3762-041     | FRONT LEG FITTING ASSY | 1           |
| 4        | AN5-13A       | BOLT                   | 1           |
| 5        | MS21042L5     | NUT                    | 2           |
| 6        | NAS1149D0568J | WASHER (AN960JD516)    | 3           |
| 7        | AN45-13A      | EYE BOLT               | 1           |



# **D3782-041 FRONT INBOARD LEG ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 6 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH  
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

|            |                    |  |              |
|------------|--------------------|--|--------------|
| A          | NEW ISSUE          | HS   | 08.06.04     |
| REV.       | DESCRIPTION        | BY   | DATE         |
| DESIGN     | HS                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | HS                 |  |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.  | REV. A       |
| MFG. APPR. | <i>[Signature]</i> | D3782  | SHEET 1 OF 4 |
| APPROVED   | <i>[Signature]</i> | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i> | LEG ASSEMBLY   | NTS          |
| DATE       | 08.06.04           | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

**RELEASED**  
08-06-11  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42151





| ITEM NO. | PART NUMBER   | DESCRIPTION            | QTY. (-043) |
|----------|---------------|------------------------|-------------|
| 1        | D3768-3       | FRONT OUTBOARD LEG, LH | 1           |
| 2        | D3787-1       | FOOT                   | 1           |
| 3        | D3762-041     | FRONT LEG FITTING ASSY | 1           |
| 4        | AN45-13A      | EYE BOLT               | 2           |
| 5        | MS21042L5     | NUT                    | 2           |
| 6        | NAS1149D0568J | WASHER (AN960JD516)    | 2           |

# **D3782-043 FRONT OUTBOARD LEG ASSY, LH**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | HS       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | HS       |  |              |
| CHECKED    |          | DRAWING NO.<br><b>D3782</b>  | REV. A       |
| MFG. APPR. |          |  | SHEET 2 OF 4 |
| APPROVED   |          | TITLE<br><b>LEG ASSEMBLY</b>   | SCALE<br>NTS |
| DE APPR.   |          | COPYRIGHT © 2008 BY DART AEROSPACE LTD   |              |
| DATE       | 08.06.04 | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

**RELEASED**  
08.06.14.107

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42151





| ITEM NO. | PART NUMBER   | DESCRIPTION            | QTY. (-044) |
|----------|---------------|------------------------|-------------|
| 1        | D3768-4       | FRONT OUTBOARD LEG, RH | 1           |
| 2        | D3787-1       | FOOT                   | 1           |
| 3        | D3762-041     | FRONT LEG FITTING ASSY | 1           |
| 4        | AN45-13A      | EYE BOLT               | 2           |
| 5        | MS21042L5     | NUT                    | 2           |
| 6        | NAS1149D0568J | WASHER (AN960JD516)    | 2           |

# **D3782-044 FRONT OUTBOARD LEG ASSY, RH**

**RELEASED**  
08-06-16/17

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42151

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | HS       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | HS       |   |              |
| CHECKED    |          | DRAWING NO.   | REV. A       |
| MFG. APPR. |          | D3782   | SHEET 3 OF 4 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | LEG ASSEMBLY  | NTS          |
| DATE       | 08.06.04 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |



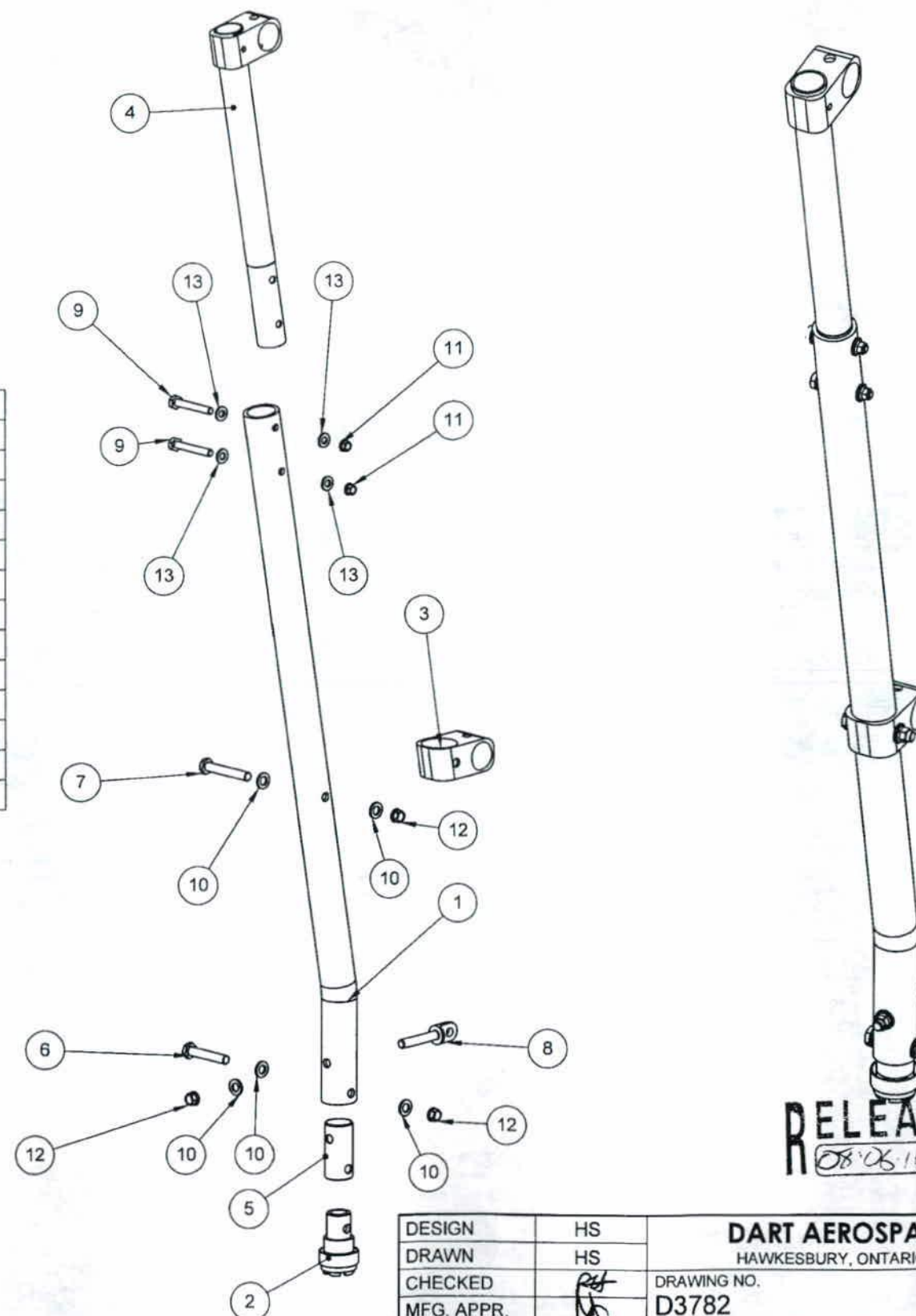


| ITEM NO. | PART NUMBER   | DESCRIPTION            | QTY. (-045) |
|----------|---------------|------------------------|-------------|
| 1        | D3772-1       | BACK LEG               | 1           |
| 2        | D3787-1       | FOOT                   | 1           |
| 3        | D3764-1       | BACK LEG FITTING       | 1           |
| 4        | D3773-041     | HEAD REST ADAPTER ASSY | 1           |
| 5        | D3786-1       | SLEEVE                 | 1           |
| 6        | AN5-15A       | BOLT                   | 1           |
| 7        | AN5-17A       | BOLT                   | 1           |
| 8        | AN45-15A      | EYE BOLT               | 1           |
| 9        | AN4-15A       | BOLT                   | 2           |
| 10       | NAS1149D0568J | WASHER (AN960JD516)    | 5           |
| 11       | MS21042L4     | NUT                    | 2           |
| 12       | MS21042L5     | NUT                    | 3           |
| 13       | NAS1149D0463J | WASHER (AN960JD416)    | 4           |

### D3782-045 BACK LEG ASSY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs



|            |                 |  |              |
|------------|-----------------|--|--------------|
| DESIGN     | HS              | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | HS              | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |                 | DRAWING NO.  | REV. A       |
| MFG. APPR. |                 | <b>D3782</b>   | SHEET 4 OF 4 |
| APPROVED   |                 | TITLE  | SCALE        |
| DE APPR.   |                 | <b>LEG ASSEMBLY</b>  | NTS          |
| DATE       | <b>08.06.04</b> | COPYRIGHT © 2008 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

**RELEASED**  
08/06/15/14

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42151

